

Work Order ID 128128

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Item ID: D350-567-145 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Window Close Out (AS350 B3e)
 Start Date: 1/07/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/09/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9590	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-145 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 1501-08
 DAS 27 9:00
 1x
 DAS 46
 JAN 09 2015

DAS 27 9:00
 15/1/7
 1x

DAS 27 9:00
 1x
 DAS 46
 JAN 09 2015

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Item ID: D350-567-145

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 1/07/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/09/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130							DAS		JAN 09 2015
Packaging	Memo	0.00					46		
Packaging	Identify and pack for shipping as per PPP D350-567-145						9.89		
	Location: <u>FG033</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 15-01-12ME
15-01-09

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D350-567-145

Required Date: 1/09/15

Required Qty: 1.00

Comments: IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CB200		Purchased	No				Each	26.0000		17		DAS 27 8-89	
CB200 Acrylic Adhesive, 3.5G	DAS 43 0-89								**			JAN 07 2015	DAS 05 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA2				36					
					129452			18					
					130685			18		1			
				MF				-10					
					129452			-10					
D4730-020-030		Manufactured	No				Each	0.0000		1		DAS 27 8-89	
D4730-020-030 Velcro Strip 2.0W/ X 3.0L	DAS 43 0-89								**			JAN 07 2015	
D4971-041		Manufactured	No				Each	2.0000		1		DAS 27 8-89	
D4971-041 T/R Bellcrank Cover Assembly	DAS 43 0-89								**			JAN 07 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST621				2					
					120665			2		1			
D5076-041		Manufactured	No				Each	1.0000		1		DAS 27 8-89	
D5076-041 Fwd Bracket Assembly	DAS 43 0-89								**			JAN 07 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST618				1					
					126824			1					

Picklist Print

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Work Order ID: 128128

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 1/07/15

Required Date: 1/09/15

Start Qty: 1.00

Required Qty: 1.00

D3802-1

Manufactured No

f

212.0000

D3802-1

Windows Seal (\$ Per Foot)

DAS

**

DAS
27
9-89

JAN 07 2015

Location

Loc Qty

Loc Code

ST421

212

116673

6

122222

206

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

D4435-9

Manufactured No

Each

8.0000

D4435-9

Bracket

DAS

**

DAS
27
9-89

JAN 07 2015

Location

Loc Qty

Loc Code

ST107

8

126472

8

Each

0.0000

D4436-041

Manufactured No

D4436-041

Aft Bracket Assembly

DAS

**

D4441-1

Manufactured No

f

668.0000

D4441-1

Rubber Seal

DAS

**

9-89

DAS

Location

Loc Qty

Loc Code

ST407

418

120932

418

ST422

250

120932

250

(D4441-1-240) CUT (1) AT 24.00" PER KIT

123608

B123608 & 15117

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Shop Packet Print

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Work Order ID: 128128

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 1/07/15

Required Date: 1/09/15

Start Qty: 1.00

Required Qty: 1.00

AN3-3A Purchased No

Each 355.0000

AN3-3A

Bolt

DAS

43

9-89

**

5

DAS

27

9-89

JAN 07 2015



AN525-10R6 Purchased No

Each 200.0000

AN525-10R6

Screw

DAS

43

9-89

**

S

2

DAS

27

9-89

JAN 07 2015



AN525-832R7 Purchased No

Each 85.0000

AN525-832R7

Screw

DAS

43

9-89

**

S

2

DAS

27

9-89

JAN 07 2015



MS21042L06 Purchased No

Each 286.0000

MS21042L06

Nut

DAS

43

9-89

**

S

1

DAS

27

9-89

JAN 07 2015



Location

Loc Qty

Loc Code

ST350

355

m129591

355

Location

Loc Qty

Loc Code

ST273A

100

M129390

100

ST329

100

M130325

100

Location

Loc Qty

Loc Code

GA

72

m129909

72

ST329

13

m127363

13

Location

Loc Qty

Loc Code

ST305

286

m129499

86

m130325

200

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Work Order ID: 128128

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 1/07/15

Required Date: 1/09/15

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

Each

1,002.000

MS21042L08

DAS

Nut

**

DAS
27

JAN 07 2015

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST304

901

123900

16

m128401

285

m130325

600

MS21042L3

Purchased

No

Each

570.0000

MS21042L3

DAS

Nut

**

DAS
27

JAN 07 2015

Location

Loc Qty

Loc Code

FP001

489

M130922

489

ST305

78

M130799

78

ST307

3

123900

3

MS21059L3

Purchased

No

Each

170.0000

MS21059L3

DAS

Nut Plate

**

DAS
27

JAN 07 2015

Location

Loc Qty

Loc Code

CA

16

M129682

16

GA

136

M130823

136

ST302

18

M130823

18

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Work Order ID: 128128

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Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 1/07/15

Required Date: 1/09/15

Start Qty: 1.00

Required Qty: 1.00

MS35206-229

Purchased

No

Each

90.0000

MS35206-229

DAS

43

Screw

**

DAS

27

5-89

JAN 07 2015

Location

Loc Qty

Loc Code

ST277

90

90

M131078

Each

3,027.000

NAS1149F0332P

Purchased

No

NAS1149F0332P

DAS

43

Washer

**

DAS

27

5-89

JAN 07 2015

Location

Loc Qty

Loc Code

GA

222

122063

222

ST260a

2805

m130325

2000

m131026

805

NAS1149FN616P

Purchased

No

NAS1149FN616P

DAS

43

WASHER

**

DAS

27

5-89

JAN 07 2015

Location

Loc Qty

Loc Code

st268

174

M131026

174

NAS1149FN816P

Purchased

No

NAS1149FN816P

DAS

46

WASHER

**

DAS

27

5-89

JAN 07 2015

Location

Loc Qty

Loc Code

st268

820

117310

820

REFERENCE ONLY

DAS

400
0.89

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELL CRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELL CRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

E

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	14.03.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	